

Date: Wednesday, 3/12/2008 1:48:26 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number	: 37865		
Estimate Number	: 10832		
P.O. Number	:	Part Number	: D29322
This Issue	: 3/12/2008 S.O. No. :	Drawing Number	: D2932 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 35477	Material	:
Written By	:	Due Date	: 4/4/2008 Qty: 6 Um: Each
Checked & Approved By	: <u>AF 08 03 12</u>		
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC Est Rev: C As per Rev C 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Issue material from stock: 7075-T7351 (QQ-A-250/12)
 Cut Size 2.0 x 6.25 X 7.88
 Grain Along Long 7.88 Length
 Batch No: 034873

2F 08/04/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number.
 1-Inspect part number and batch number are programmed correctly.
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet
 5-Deburr

DIP 08/04/08 2F 08/04/07

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

DIP 08/04/08 2F 08/04/07

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

DIP 08/04/08 2F 08/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/12/2008 1:48:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 37865

Part Number: D29322

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/04/10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BL 08-04-14

(6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 08/04/14 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SS BL 08-04-14

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST428

SS 08/04/14

(6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15

Job Completion



mf 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 37865
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.129	0.127	0.128	0.128		
B	0.100	0.140		.126	0.125	0.124	0.124		
C	0.100	0.140		.130	0.129	0.129	0.129		
D	0.210	0.230		.221	.218	.225	0.220		
E	1.245	1.255		1.250	1.248	1.2475	1.248		
F	1.245	1.255		1.250	1.249	1.2485	1.248		
G	2.495	2.505		2.500	2.499	2.4985	2.499		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.258	.258	0.259		
L	0.312	0.317		.316	0.316	0.316	0.316		
M	0.235	0.240		.238	0.237	.237	.237		
N	0.100	0.140		.119	.119	.119	0.120		
O	0.540	0.560		.557	0.557	0.5555	0.559		
P	0.490	0.510		.503	0.500	0.500	0.506		
Q	3.715	3.725		3.718	3.718	3.718	3.719		
R	2.470	2.510		2.491	2.496	2.496	2.491		
S	0.240	0.270		.252	0.249	0.249	0.250		
T	0.100	0.180		.18 .140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.628		
V	1.362	1.372		1.370	1.370	1.370	1.366		
W	0.316	0.321		.321	.321	.321	0.321		
X	1.125	1.145		1.136	1.136	1.136	1.1365		
Y	1.565	1.585		1.574	1.577	1.577	1.575		
Z	0.178	0.198		.188	.188	.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>RF</i>
Date: 08/04/08

Audited by: <i>JA</i>
Date: 08/04/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

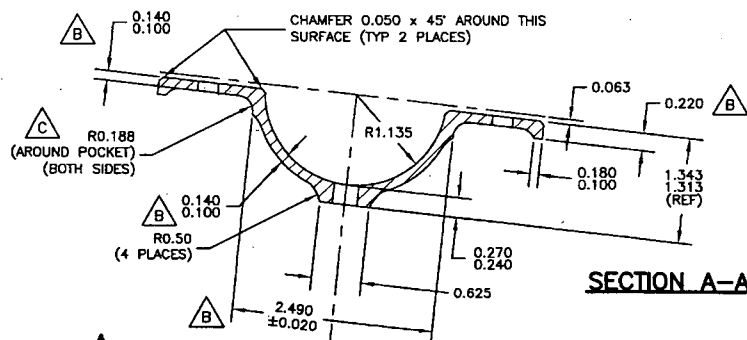
DART AEROSPACE LTD	Work Order: 37865
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

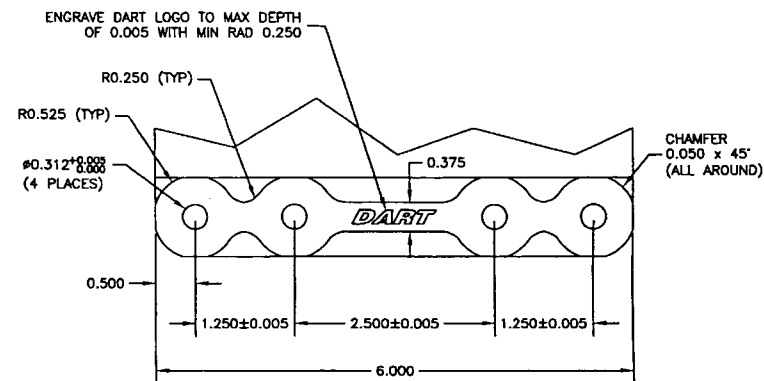
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	3	4		
A	0.100	0.140		0.127	0.127				
B	0.100	0.140		0.126	0.125				
C	0.100	0.140		0.125	0.124				
D	0.210	0.230		0.220	0.223				
E	1.245	1.255		1.249	1.249				
F	1.245	1.255		1.248	1.248				
G	2.495	2.505		2.499	2.499				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.576				
J	2.495	2.505		2.499	2.499				
K	0.257	0.262		0.259	0.259				
L	0.312	0.317		0.316	0.316				
M	0.235	0.240		.237	.237				
N	0.100	0.140		0.120	0.123				
O	0.540	0.560		0.557	0.557				
P	0.490	0.510		0.505	0.505				
Q	3.715	3.725		3.719	3.719				
R	2.470	2.510		2.491	2.491				
S	0.240	0.270		0.250	0.250				
T	0.100	0.180		0.140	0.140				
U	1.625	1.635		1.629	1.628				
V	1.362	1.372		1.367	1.366				
W	0.316	0.321		0.321	0.321				
X	1.125	1.145		1.136	1.136				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DJP</u>	Audited by: <u>SD</u>
Date: <u>03/04/08</u>	Date: <u>08/04/10</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

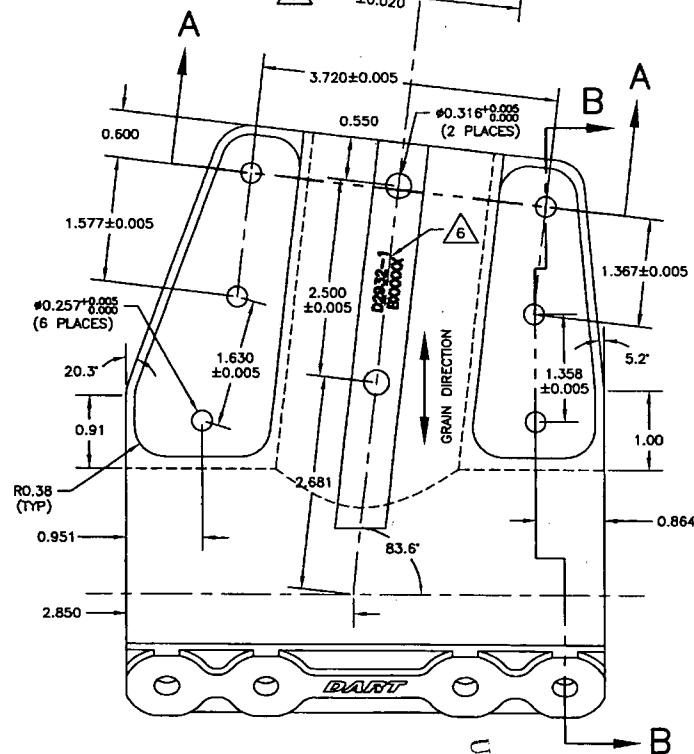
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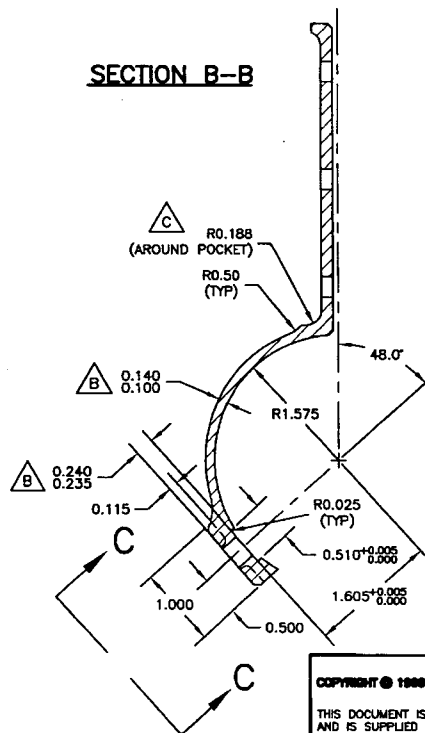
DART DART AEROSPACE USA, INC.
BOLLENE, WA

DRAWING NO. D2932

TITLE SADDLE OUTSIDE



SECTION B-B



RELEASED

070212

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